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D206-667-103TRN
Job Sheet 202589



Part No: D206-667-103TRN

Job Qty: 1 pcs

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/19

Job Tracking No:

Due Date: 11/13/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev: A 08-03-06 new issue DD verified by: ec IPP Rev B 08.04.02 removed polish EC verified by DD

Ship Via:

DWG Rev D

DAS
35
9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Mori Seiki TL-40 - 1	1 pcs		11/13/19	1.00	2.10	Mori Seiki TL-40 - 1			DAS 66 2019/10/31 9-89
110	QC 2	1 pcs		11/13/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			DAS 66 2019/10/31 9-89
							QC 2 - 65			
							QC 2 - 64			

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120	Mori Seiki TL-40 - 1 - B4B	1 pcs	11/13/19	1.00 2.10	Mori Seiki TL-40 - 1 - B4B
130	QC 2	1 pcs	11/13/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
					QC 2 - 66
					QC 2 - 64
					QC 2 - 65
					QC 2 - 5
					QC 2 - 71
					QC 2 - 73
					QC 2 - 69
140	QC 8	1 pcs	11/13/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68

DAS
66 2019/11/04
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DAS
66 2019/11/04
9-89

				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	DAS
				QC 8 - 76	76
				QC 8 - 61	9-89
145 Crosstubes - 2 - B4B	1 pcs	11/13/19	0.00 0.59	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	BIS 11/22/2019
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	
150 Handfinish - 1-1 Chemical- B4B	1 pcs	11/13/19	0.00 1.00	Handfinish - 1 - 1 - B4B	BEB 19-11-25
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	11/13/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	

				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	DAS
				QC 7 - 76	76
				QC 7 - 79	9-89
170 Packaging 3-1 - Stock - B4B	1 pcs	11/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS 11/25/2019
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	11/13/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21 NOV 25 2019

Part Op 100 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Fill tube with sand & install plugs DT8534 on both ends as per

Descriptions: Folio FA087 2-Turn first side as per Folio FA087 3-Blend transition lines only, **do not sand whole tube**: FOLIO REV: 2 DWG REV: 2 *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.
110 - QC2-1 (QC2- Inspect parts off machine FAI/FAIB) QC2- Inspect parts off machine FAI/FAIB
120 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Turn second side as per Folio FA087 2-File down transition lines smooth, 3-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. FOLIO REV: 2 DWG REV: 2 *Do not use sandpaper coarser than 320 grit.
130 - QC2-1 (QC2- Inspect parts off machine FAI/FAIB) QC2- Inspect parts off machine FAI/FAIB
140 - QC8 (QC8- Inspect parts - second check) QC8- Inspect parts - second check
145 - Crosstubes-1 (Crosstubes) GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
150 - Crosstubes-3 (Crosstubes) 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT. USE RED SCOTCH BRITE
160 - QC7-1 (QC7-Inspect Chemical Conversion Coat) QC7-Inspect Chemical Conversion Coat
170 - Identify and stock in kanban rack Location: _____
180 - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6002-115	Crosstube Material	1 pcs (1 ea)	100-Mori Seiki TL-40 - 1	F123961

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6002-115	1	64	0

Part Specifications

Specifications could not be found.

Plex 10/30/19 1:41 PM Dart.lajeunesse.marie



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CANADA
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Container No: S228870



Part: D206-667-103TRN

Job No: 202589

Serial No/Batch: S228870

Revision: D

Inspector:

Exp Date:

Instructions:

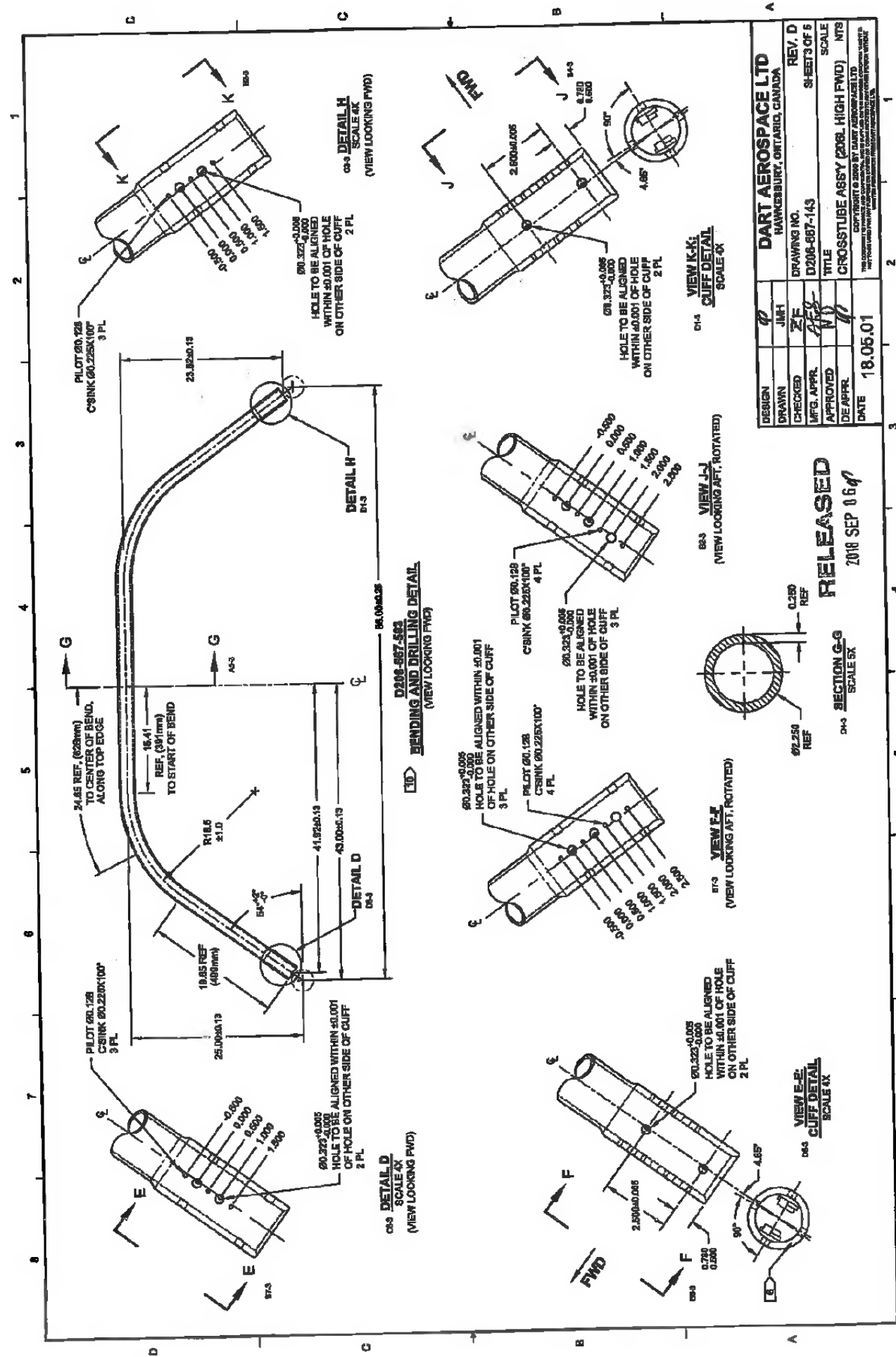
Date: 10/31/19

④

DART AEROSPACE LTD		Work Order:	202588
Description: Crosstube Assembly (206L High Fwd)		Part Number:	D206-667-143
Inspection Dwg: D206-667-143 Rev: <i>ED</i>			Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.241	✓		CNC-04	
	1.982	+0.005/-0.000	1.986	✓		CNC-08	
	2.019	+0.005/-0.000	2.024	✓		CNC-04	
	2.058	+0.005/-0.000	2.063	✓		↓	
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.140	✓			
	2.176	+0.005/-0.000	2.180	✓			
	2.201	+0.005/-0.000	2.206	✓			
	0.125	+/-0.010	.128	✓		CNC-08	
	0.400 x 30°	+/-0.010	.400	✓		"	
	R0.063	+/-0.010	.063	✓		AG	
	R0.500	+/-0.010	.500	✓		"	
	4.438	+/-0.030	4.438	✓		CNC-08	
SIDE B	104.98	+/-0.020	105.00	✓		tape	
	2.240	+0.005/-0.000	2.241	✓		CNC-04	
	1.982	+0.005/-0.000	1.986	✓		CNC-08	
	2.019	+0.005/-0.000	2.024	✓		CNC-04	
	2.058	+0.005/-0.000	2.063	✓		↓	
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.141	✓			
	2.176	+0.005/-0.000	2.181	✓			
	2.201	+0.005/-0.000	2.206	✓			
	0.125	+/-0.010	0.127	✓		CNC-08	
	0.400 x 30°	+/-0.010	.400	✓		"	
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		"	
	4.438	+/-0.030	4.438	✓		CNC-08	



DESIGN

2018 SEP 16 PM

SECTION 6-6

SECTION 6-9

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



NCR No.

Job:

Part No.

Date :

Sequence #:

QTY Affected :

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

DISPOSITION

Rework
Scrap
Use-as-is

DEPARTMENT/PROCESS

Skid-tube
Machining
Large Fab

Crass tube
Small Fab
Finishing

Eng. (Non-AW)
Prod. Eng. Coord.
Rec/Store/Packaging

Engineering
Water Jet
Supplier
Quality

Root Cause

Operator
Manufacturing Process
Equip/Tooling
Handling/Presservation
Material
Product Improvement
Process Improvement
Human Factors

FAULT CATEGORY

Pressure/Forced
Bending
Crushing
Cracks
Crimp/Kink/Ripple/Wave/Twist
Marks/Chatter
Mislabeled

Contamination
Misaligned/off center
BOM/Route
Broken/Damage/Defect
Incomplete/Unclear Instructions
Drill Holes
Fit/Function

Power Loss/Surge
Folio/Program
Grain Direction
Weld
Wrong Stock Pulled
Out of Sequence
Off-set/Set-up

Positioned Wrong
Outside Tolerance
Drawing
Finish
Part Lost/Missing
Misread

Other/Details: